

Work Order ID 54015

November 25, 2009 3:18:37 PM

Page 1

Item ID: D3916-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Rib ass'y

Start Date: 11/26/2009 Start Qty: 1.00

Required Date: 12/11/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: *mf*

Date: 09-11-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A-Prelim

ASS 09.11.26

0.00

100



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 54"
- 2- Bend tube with manuel pipe bender as per dwg D3916-3
- 3- Drill and chamfer holes as per dwg D3916-3
- 4- Trim access tube material to finish size as per dwg D3916
- ~~5- weld bushing as per dwg D39T6~~
- ~~6- grind welds flush~~

MATERIAL CERTIFICATION

REQ'D UPON DELIVERY

09/12/22

09/12/22

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

110

*① Weld Bushing and grind Weld Flush
SS. Rod Batch: M109213*

PD 10.01.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54015

November 25, 2009 3:18:37 PM



Page 2

Item ID: D3916-043

Accept



Setup Start



Revision ID:

Item Name: Fwd Rib ass'y

Stop



Start Date: 11/26/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

2) S 10/01/04



130

Identify as per dwg & Stock Location: bucket

0.00



Packaging

Memo

0.00

Packaging

8D 1001.04

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

R200308A JAN

#1010106 (used as template)

R/10-1-06

POSITIVE RECALL

EFFECTIVE 09.12.11 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 25, 2009 3:18:37 PM

Page 1

Work Order ID: 54015

Parent Item: D3916-043

Parent Item Name: Fwd Rib ass'y

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC

Start Date: 11/26/2009

Required Date: 12/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3759-1RevA

Manufactured

No

100

Each

36.0000

3.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

36

53442

36

M304TS0.750W.049

Purchased

No

100

f

164.6000

4.7368



304 SQ Tube .75x.75x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

164.6

103240

10

106604

16.6

107460

38

109087

100

PD 10.01.04

11/09/12/22

9.4736

Use opp for a template

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

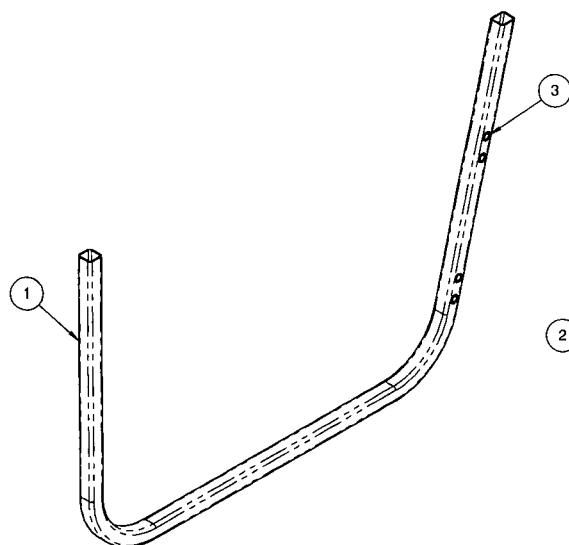
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3916-041	AFT RIB ASSY
		X	D3916-043	FWD RIB ASSY
1	1		D3916-1	AFT RIB
2		1	D3916-3	FWD RIB
3	4	3	D3759-1	BUSHING

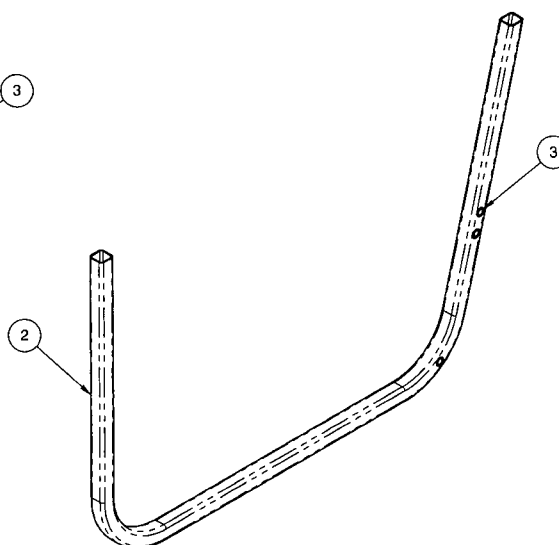
PRELIMINARY ISSUE

13509.11.26

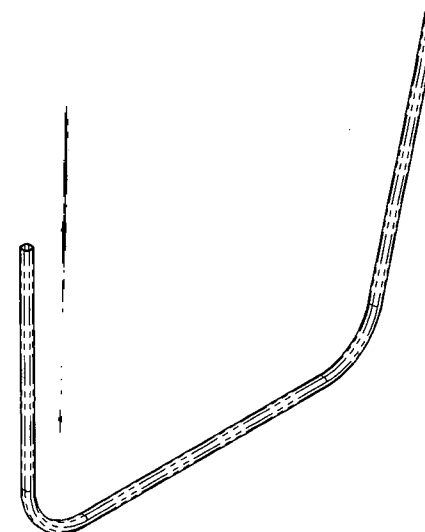
#54015



D3916-041 AFT RIB ASSY



D3916-043 FWD RIB ASSY



D3916-5 LIGHT RIB

A	PRELIMINARY (1)	AJS	09.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	09.11.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

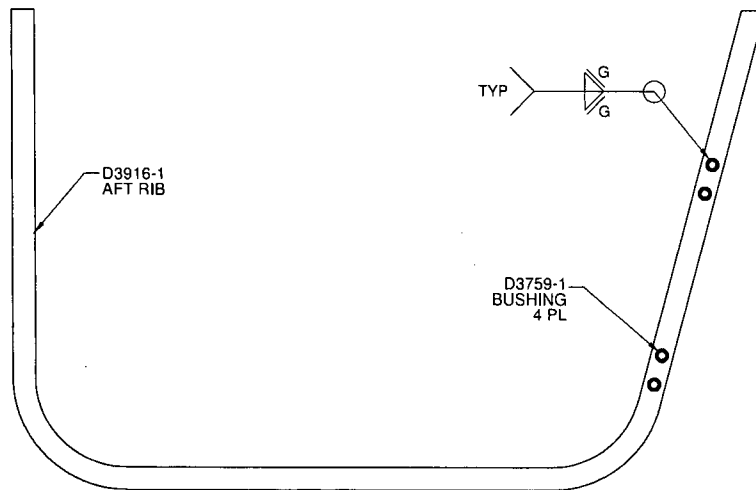
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

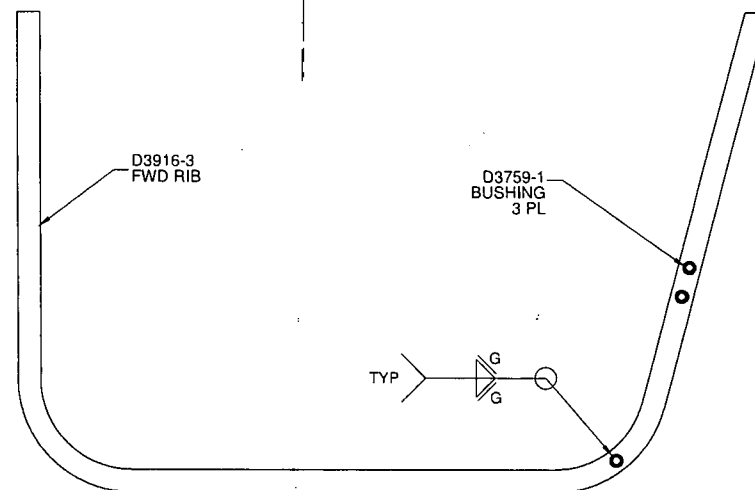
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#54015



D3916-041 AFT RIB ASSY



D3916-043 FWD RIB ASSY

PRELIMINARY ISSUE

AJS 09.11.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.85 lbs
-043: 1.84 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3916	REV. A
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	09.11.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

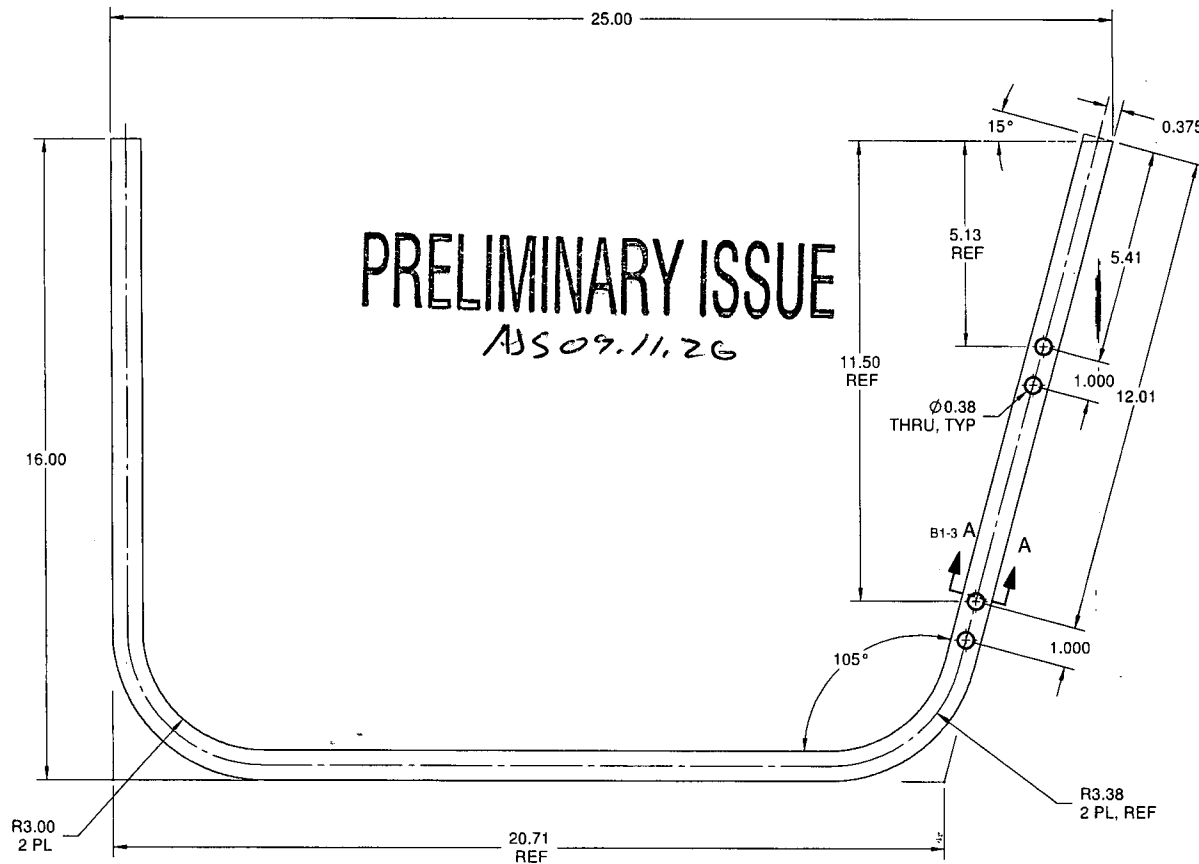
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE
AS 09.11.26

#54015



9 D3916-1 AFT RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.80 lbs
- 9) TUBE FLAT LENGTH 50.83 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3916	REV. A
MFG. APPR.		TITLE RIB ASSY, 350 BASKET	SHEET 3 OF 5
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.11.19		

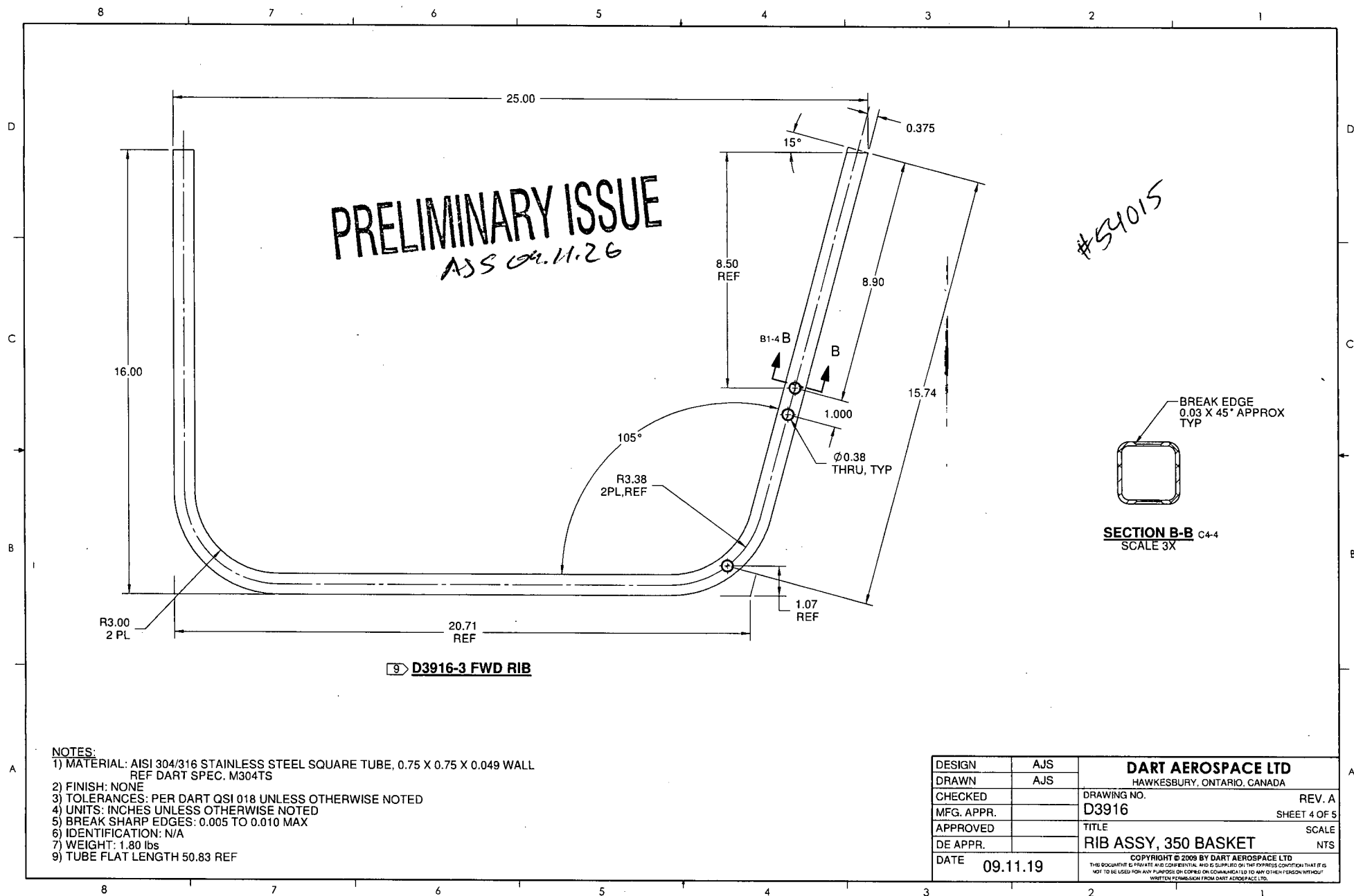
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 8/8/09 Batch No: M128087
 Supplier: MAGNA Dart P/O: 7019

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☒ No ☐ N/A ☐
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☐ No ☒ N/A ☐
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ok ☒ N/A ☐
 Work Order 4617 ☒ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 08/09/02
 Date: 08/09/02
 Received/Costing: BCP 8763
 Initial: CG

Location _____



Magna Stainless division de CSM Inc.

525 Meloche Ave., Dorval (Québec) H9P 2W2

Tél.: (514) 631-1211 • Fax: (514) 631-0013

Sans frais / Toll free: 1-800-363-6646

ISO 9001-2000

N° FACTURE / INVOICE NO.

164382

VENDU À - SOLD TO

DART

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY

ONTARIO

K6A 1K7

EXPÉDIÉ À - SHIPPED TO

MEME - SAME

DATE	N° LIVR. - DEL. NO.	PAR - VIA	N° COMM. DU CLIENT CUST. ORDER NO.	CONDITIONS - TERMS	N° T.V.Q. - Q.S.T. NO.	N° T.P.S. - G.S.T. NO.	
Aug29/08	0174394	NIR:R-557065-1	7019		1213236471	881565899 RT0001	
QTE EXP. QTY SHIPPED	DESCRIPTION			POIDS EXPÉDIÉ WEIGHT SHIPPED	PRIX - PRICE	UNITÉ UNIT	TOTAL
	304 180 GRIT						
5	3/4" SQ 18GA X 20' HEAT TUYU238460 Heat # 174394 SHIPPED WITH 174638				28.00	PCS	140.00
RECEIVED SEP 08 2008							
Sub-Total							140.00
G.S.T.							7.00

RAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

TOTAL →

147.00

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date	Page
Sep 2, 2008	1
Receipt Number RCP00008763	

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007019

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304TS0750W049	304 SQ Tube .75x.75x. MATERIAL: AISI 304/316 SS SQUARE TUBING B/N109087	100.0000 f		1.400000	140.00	Sep 02, 2008

Comments:

MAGNA

INOXYDABLE

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0174394

ADU À /
AD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
270 ABERDEEN STREET
IAWKESBURY
ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

COMMANDE / SALES ORDER		CODE DE CLIENT / CUSTOMER CODE		BON D'ACHAT / BON VENTE / CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT / CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT / CUSTOMER FAX NO.	
0174394		DART		7019		613 632-5200		632-1053	
NIR: R-557065-1		NET 30		Aug-26-08		Aug-29-08		15 26 EB	
CONTRÔLE DE QUALITÉ DU CLIENT / REQUIS / CUSTOMER QUALITY RELEASE REQ'D		<input type="checkbox"/>		CONTRÔLE DE QUALITÉ DE MAGNA / REQUIS / MAGNA QUALITY RELEASE REQ'D		<input type="checkbox"/>		PRÉPAYÉ / PRÉPAID <input type="checkbox"/> À PERCEVOIR / COLLECT <input type="checkbox"/>	
QUANTITÉ / QUANTITY	UNITÉ / UNIT	DESCRIPTION				QTE LIVRÉE / QTY SHIPPED	PRIS PAR / PRICE PER	INSTRUCTIONS DE L'USINE / PLANT INSTRUCTIONS	
5	pcs	304 180 GRIT 3/4" SQ 18GA X 20"				100/474		5 pcs CK358	
TOTAL :								LBS	

LIBRE DE PAQ.
LIBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER

POSTE
MAIL

TÉLÉCOPIEUR
FAX

PACKING SLIP / BON D'EMBALLAGE

ge: 1

11:28:12

20080826

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:



WINNER STAINLESS STEEL TUBE CO.,LTD

ORIGINAL



ADDRESS: 3RD INDUSTRIAL PARK, XIAOBU VILLAGE, HUASAN TOWN, HUADU DISTRICT, GUANGZHOU, P.R.C.
TEL: +86-20-86847851 FAX: +86-20-86941744

MILL TEST CERTIFICATE

Issued Date: 2006/10/12

Customer:

Order No.: 119

Certificate No.: GUL-F684

Article: Stainless steel mechanical structures welded tube						Specification: ASTM A554-03							
Item No.	Size	Length	Qty.Pcs	Net Weight	Type	Heat No.	Annealed Temperature (°F)	Hold Time (minute)	Cooling	Surface Finish	Hydrostatic Test (psi)	ET	
6~7#	3/4"SQ×18GA	20'	200	816.86	MT304	TU-YU238460	—	—	—	180Grit	—	—	
8#	3/4"SQ×18GA	20'	48	196.05	MT304	TU-YU238460	—	—	—	180Grit	—	—	
9~12#	3/4"SQ×16GA	20'	400	2145.80	MT304	TU-YU238951	—	—	—	180Grit	—	—	
13#	3/4"SQ×16GA	20'	27	144.84	MT304	TU-YU238951	—	—	—	180Grit	—	—	
14#	3/4"SQ×16GA	20'	19	101.93	MT304	TU-YU142400	—	—	—	180Grit	—	—	
Chemical Composition (%)									Mechanical Test				
	C	Mn	P	S	Si	Ni	Cr	Mo	T. S. (Ksi)	Y. S. (Ksi)	Elongation(%)	Flattening	
MIN						8.00	18.00	—	≥75	≥30	≥35	≤2/3D	
MAX	0.080	2.00	0.040	0.030	1.00	11.00	20.00	—					
6~7#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
8#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
9~12#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
13#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
14#	0.023	1.41	0.035	0.007	0.44	8.09	18.21	—	92	50	51	good	
Remarks:						We, Winner Stainless Steel Tube Co., Ltd., hereby certify that the products described herein have been manufactured in accordance with the standards and specifications specified as above and meet the requirements.							
1. Corrosion test: as per ASTM-A262, Practice E accepted. 2. Dimensions & Visual: good. 3. Materials are free from mercury contamination.													
						Q. C. Manager/Work Inspector							

536.93 536.94 536.95



Purchase Order

Date Aug 25, 2008	Page 1
Purchase Order Number PO00007019	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Aug 25, 2008	N30	yours	Aug 26, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/26/2008	No	6.406250	sf	2,050.00
320.0000	M304S22GA	304/316 .032 Sheet Comments: AS ABOVE	8/26/2008	No	3.281250	sf	1,050.00
100.0000	M304TS0750W049	304 SQ Tube .75x.75x.0 Comments: MATERIAL: AISI 304/316 SS SQUARE TUBING	8/26/2008	No	1.400000	f	140.00
80.0000	M6061T6A1000W125	6061T6 ANGLE 1.00 x 1. Comments: MATERIAL: 6061-T6 /T6510/6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8	8/26/2008	No	0.675000	f	54.00
200.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1/8 Comments: MATERIAL: 6061-T6 OR 6061-T6511/T6510/T6511/T62 SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	8/26/2008	No	1.500000	f	300.00
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div> <div>M109.57 M109.087</div>							
Comments:		Tax Summary:		Less:			
		GST		included tax		0.00	
		ONTPST		Subtotal		3,594.00	
				Total tax		179.70	
				Total purchase order in			
				CAD Dollars		3,773.70	